

# Work Order ID 74302

Wednesday, September 28, 2011 10:47:50 A

Page 1

Item ID: D4092-042  
 Revision ID: ~~D40~~ *ACN11.639*  
 Item Name: Maintenance Step Assembly

Accept



Setup Start



Stop



Start Date: 9/28/2011 Start Qty: 5.00  
 Required Date: 10/14/2011 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*Pick 10/12 (5)*

110

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in- lbs

*Small 10/14 (5)*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*to Rev B Dwg -  
5/12/14*

*(18)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74302

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Page 2

Item ID: D4092-042  
Revision ID: U/R  
Item Name: Maintenance Step Assembly

Accept



Setup Start



Stop



Start Date: 9/28/2011 Start Qty: 5.00  
Required Date: 10/14/2011 Req'd Qty: 5.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Packaging								
	Memo PMP 74203	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

*Signature*  
10/10/11

*Signature*  
11/10/11  
MF 11-10-11

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 28, 2011 10:47:46 AM

Page 1

Work Order ID: 74302

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly








Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD  
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 		Manufactured	No				Each	0.0000		10			
Maintenance Step										74303			
D4093-1 		Manufactured	No				Each	0.0000		5			
Bracket										74305			
D4093-3 		Manufactured	No				Each	0.0000		5			
Bracket										74306			
D4093-5 		Manufactured	No				Each	6.0000		10			
Bracket										<del>65568</del> 74307			
<div> <div>Location</div> <div>ST124</div> <div>62569</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS24694-S54 		Purchased	No				Each	148.0000		10			
Screw													
<div> <div>Location</div> <div>ST289</div> <div>118078</div> <div>ST289A</div> <div>117677</div> </div> <div> <div>Loc Qty</div> <div>100</div> <div>100</div> <div>48</div> <div>48</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
										117677			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 28, 2011 10:47:47 AM

Page 2

Work Order ID: 74302

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

MS24694-S55

Purchased

No

Each

61.0000

40



Screw



*Handwritten signature*

Location

Loc Qty

Loc Code

ST289A

61

13884

61

*13884*

MS24694-S56

Purchased

No

Each

56.0000

10



SCREW



*Handwritten signature*

Location

Loc Qty

Loc Code

ST289A

56

104407

56

*104407*

NAS1149D0332J

Purchased

No

Each

2,907.000

60



Washer



*Handwritten signature*

Location

Loc Qty

Loc Code

ST297

869

117087

869

*117087*

ST298

1038

105793

12

118078

26

118384

1000

ST302

1000

119042

1000

Wednesday, September 28, 2011 10:47:47 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, September 28, 2011 10:47:47 AM

Page 3

Work Order ID: 74302

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly



Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

Each

8,399.000

60



Nut

*Handwritten signature and date 10/15/14*

Location

Loc Qty

Loc Code

ST300

2399

117441

16

117601

240

117885

143

118451

1000

118927

1000

ST516

6000

119017

6000

118927

Wednesday, September 28, 2011 10:47:47 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

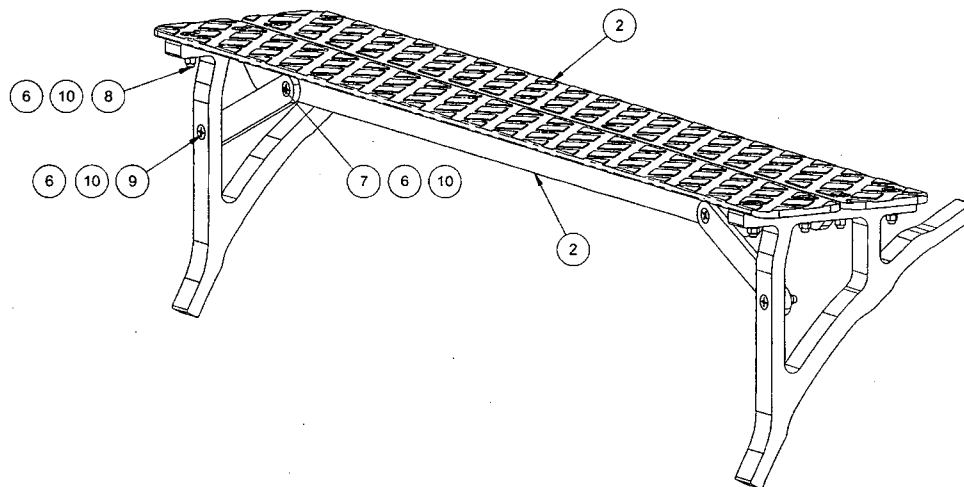
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



**D4092-042 MAINTENANCE STEP ASSEMBLY**



*W1074302*

**RELEASED**  
2011-09-22  
JW

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D4092	SHEET 2 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>14</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

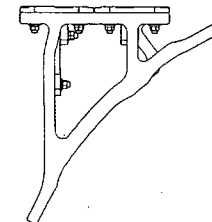
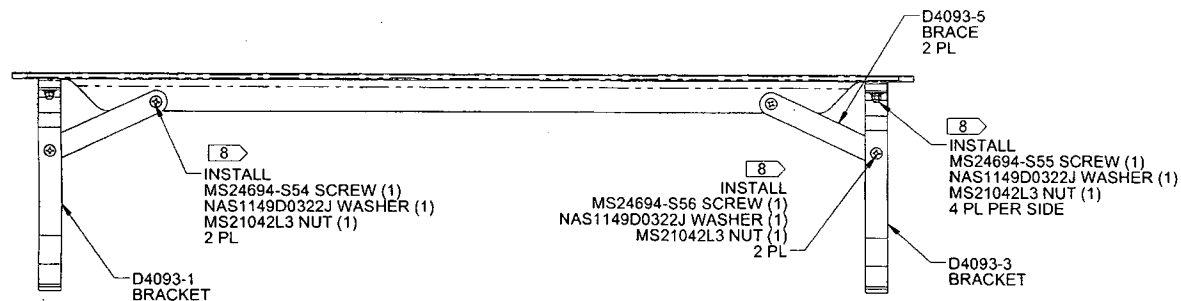
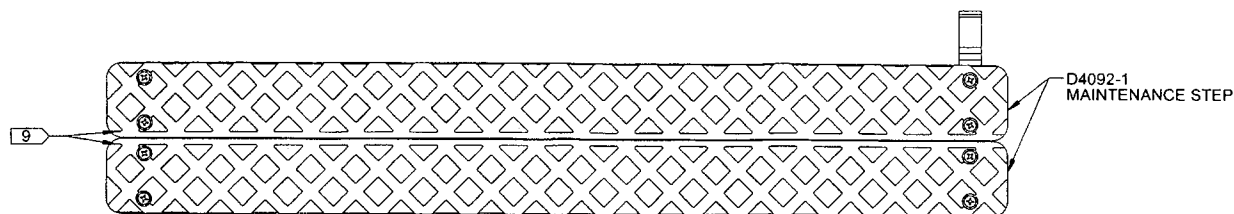
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**NOTE:** Date & initial all entries



RELEASED  
2011-09-22  
JW

### D4092-042 MAINTENANCE STEP ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 4 OF 6
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DE APPR.	140	MAINTENANCE STEP ASSY	NTS
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